

Date: Monday, 5/15/2006 11:16:27 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 27127		
Estimate Number	: 10348		
P.O. Number	: N/A	Part Number	: D28581
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D2858 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26035	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/15/2006 Qty: 24 Um: Each
Checked & Approved By	: <u>06.05.15</u>		
Comment	: Est C 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)

Material: 1.50" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B15001250)

Batch M100384

ml 06/05/24 x 24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 6.02"

Note: 1 Blank Makes 3 Parts

ml 06/05/24 x 24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

- 1-Machine per folio D2858-

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/SD 06.05.25 x 24

JL/SD 06.05.25 x 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/29

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:16:27 AM
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Drawing Name: HINGE BRACKET

Job Number: 27127

Part Number: D28581

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

SA 06.05.25 x24

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

H.M 06/05/25

(24)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 06/05/25 x24

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

A.M 06-05-25

(24)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AR 06/05/26 (24)

(24)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST391

AR 06/05/26 (24)

(24)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/05/29 (24)

(24)

Job Completion



✓ 06-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

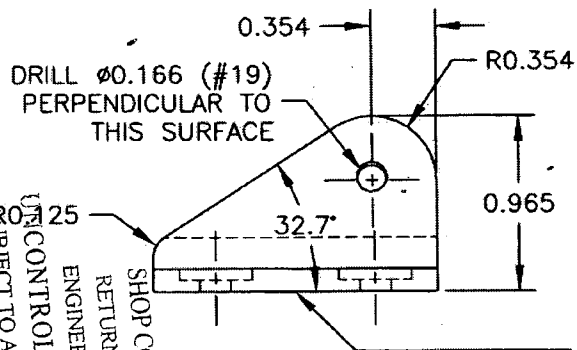
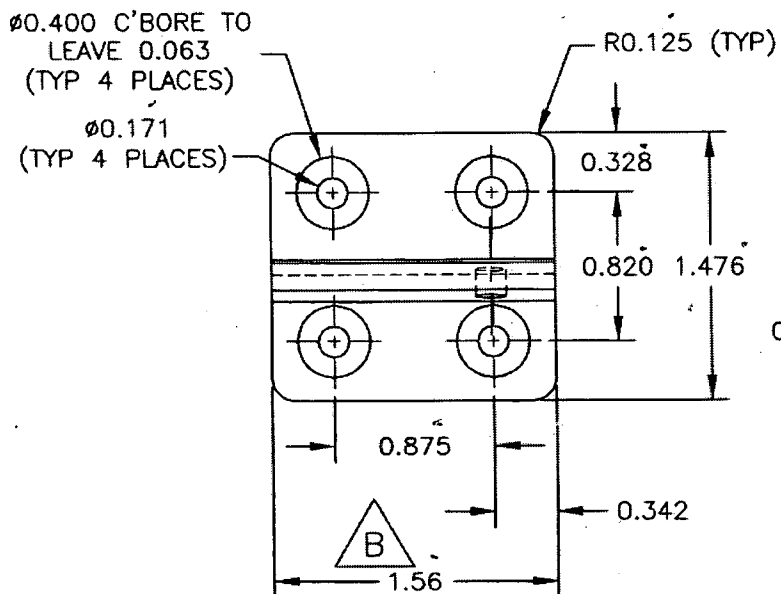
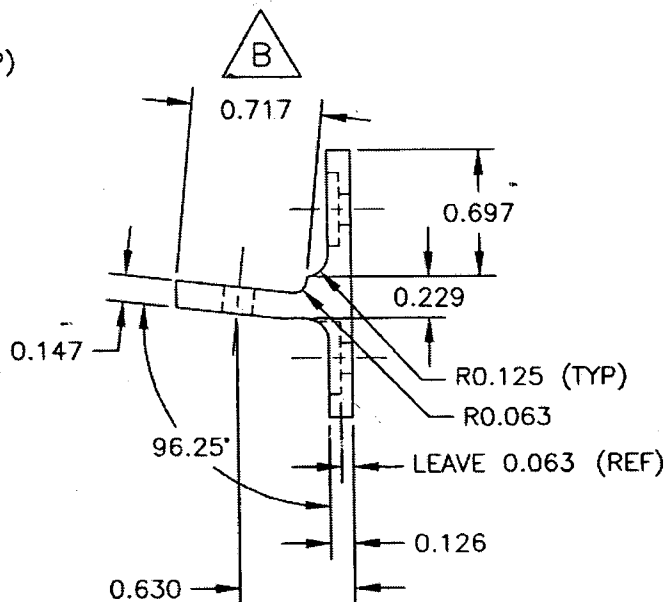
QA: N/C Closed: _____ Date: _____

DART



RELEASED
99.07.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
VE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
UP	KE	D2858
DATE	TITLE	REV. B
99.02.28	HINGE BRACKET	SHEET 1 OF 1
A	NEW ISSUE	SCALE 1:1
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 27127
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

DART AEROSPACE LTD		Work Order: 27127
Description: hinge bracket		Part Number: D2858-1
Inspection Dwg: D2858	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.476	± .010	1.477	✓			
Ø.400X.063	"	.401X.061	✓			
Ø.171	+ .005 - 0	.173	✓			
r.125	± .010	r.125	✓			
.328	"	.328	✓			
.820	"	.820	✓			
.875	"	.875	✓			
.342	"	.342	✓			
1.56	+ .030 - .010	1.565	✓			
.354	± .010	.354	✓			
Ø.166	+ .005 - .001	.168	✓			
.965	± .010	.966	✓			
.717	± .010	.719	✓			
.147	"	.148	✓			
.697	"	.698	✓			
.229	"	.230	✓			
r.125	"	.125	✓			
r.063	"	.063	✓			
.126	"	.127	✓			
.630	"	.630	✓			

Measured by: JL	Audited by: Jm	Prototype Approval:
Date: 06/05/24	Date: 06/05/24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	